

Date: Thursday, 8/23/2007 11:52:16 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PEDAL ASSEMBLY
 Job Number : 34230
 Estimate Number : 11005
 P.O. Number : N/A Part Number : D412704041
 This Issue : 8/23/2007 S.O. No. : N/A Drawing Number : D412-704-041 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
 Previous Run : 32814 Material : N/A
 Written By : Due Date : 9/3/2007 Qty: 2 Um: Each
 Checked & Approved By : 07.08.23
 Comment : Est Rev:B 05.01.28 Removed hardware on Step 2; Added
 Figures 1-3 KJ/RF
 Est Rev:C 06.03.08 Re-format EC
 Est Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20
 JLM
 Est Rev:E 07.05.02 Reformat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3204041 Pedal Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch
 1 D3204-041 Pedal Assembly 32822

AS 07/12/10

(X2)

2.0 D32051 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch
 1 D3205-1 Bracket B 30830

AS 07/12/10

(X2)

3.0 D32053 Back Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch
 1 D3205-3 GHW Bracket 35209

AS 07/12/10

(X2)

4.0 D32061 Pedal Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch

B 34239(X1) B29915(X1)

AS 07/12/10

(X2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

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Drawing Name: PEDAL ASSEMBLY

Job Number: 34230

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1

D3206-1

Pedal arm

5.0

D3209041

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3209-.041	Bracket	B30832

JS 07/12/10

(2)

6.0

AN310A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN3-10A	Bolt	M17566

JS 07/12/10

(2)

7.0

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN315-4R	Nut	M17566

JS 07/12/10

(2)

8.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-10A	Bolt	M104603

JS 07/12/10

(2)

9.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description	batch
2	AN4-12A	Bolt	108143

JS 07/12/10

(2)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: PEDAL ASSEMBLY

Job Number: 34230

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-13A	Bolt	106043

AS 07/12/10 (K2)

11.0

AN960JD10

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	AN960JD10	Washer	M105792

AS 07/12/10 (K2)

12.0

AN960JD416

Washer



Comment: Qty.: 11.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part number	Description	batch
11	AN960JD416	Washer	M105906

AS 07/12/10 (K2)

13.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part number	Description	batch
3	AN960JD416L	Washer	M105728

AS 07/12/10 (K2)

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS21042L3	Nut	M105558

AS 07/12/10 (K2)

15.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	MS21042L4	Nut	M105054

AS 07/12/10 (K2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

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Drawing Name: PEDAL ASSEMBLY

Job Number: 34230

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description:

16.0

MS24694S102

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS24694S102	Screw	M1H604

JS 07/12/10

17.0

MS951910

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS9519-10	Bolt	M100290

JS 07/12/10

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble pedal as per Dwg D412-704-041

Tighten & Torque Bolts as per Dwg D412-704-041

mlo 7/12/10

x2

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 07/12/12 (x2)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty	Part number	Description	batch
4	AN960JD10L	Washer	M104374

JS 7/12/12 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/12/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/13	#18.0	one D3204-041 was found has a bend in the location of the bottom where D3204-7 bushing was processed. (w/lot 32822)	<i>[Signature]</i>	Remove all hard was found and re label with correct BH's and Pto #1/2/3 Re stock	<i>[Signature]</i> M/A	✓	✓	<i>[Signature]</i> H12/10
			<i>[Signature]</i>	Scrap and delay the non conforming part (D3204-041) 1/7	<i>[Signature]</i> M/A	✓	✓	<i>[Signature]</i> H12/10
			<i>[Signature]</i>	Straighten D3204-041 to allow clearance when mating	<i>[Signature]</i> 07/12/13	✓	✓	<i>[Signature]</i> H12/10

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Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

AN36A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part number Description

2 AN3-6A

Bolt

batch

M100184

23.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch:

M105558

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2007/12/13

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Qty -043	Qty -045	Part Number	Description
X					D412-704-011	COPILOT'S EMERGENCY CARGO RELEASE KIT (BELL 212/ 214 / 412)
	X				D205-704-013	COPILOT'S EMERGENCY CARGO RELEASE KIT (BELL 205)
1	1	X			D412-704-041	PEDAL ASSEMBLY (205/ 212/ 214/ 412)
	1		X		D205-704-043	CABLE ASSEMBLY (205)
1				X	D412-704-045	CABLE ASSEMBLY (212/ 214/ 412)
		1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
		1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
		1			D3205-3	BACK PLATE (OR ECM 999709-5)
		1			D3206-1	PEDAL ARM (OR ECM 999704-1)
	1				D3207-1	BRACKET
1					D3207-2	BRACKET
	1				D3207-3	BRACKET
1					D3207-5	BRACKET
1	1				D3208-1	DOUBLER (OR ECM 999709-1)
1					D3208-11	FILLER
1	1				D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1				D3208-5	MOUNT ANGLE
1	1				D3208-7	FILLER (OR ECM 999709-3)
1					D3208-9	DOUBLER
		1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1				D3214-1	PLACARD (OR ECM 999712-1)
			1		D3217-1	CABLE
				1	D3217-3	CABLE
			1	1	D3257-1	FITTING
			1	1	D3258-1	ANGLE BRACKET
		1			AN315-4R	NUT
		5	2	2	AN960JD10	WASHER
		4	2	2	AN960JD10L	WASHER
		11			AN960JD416	WASHER
		3			AN960JD416L	WASHER
			3	3	NAS509-3	NUT
		3	2	2	MS21042L3	NUT (OR MS21042-3)
		5			MS21042L4	NUT (OR MS21042-4)
4	4				MS21919DG5	CLAMP
		1			MS24694-S102	SCREW
	2				MS35489-10	GROMMET
			1	1	AN3-5A	BOLT
		2			AN3-6A	BOLT
		1			AN3-10A	BOLT
			1	1	AN3-13A	BOLT
		1			MS9519-10	BOLT
		1			AN4-10A	BOLT
		2			AN4-12A	BOLT
		1			AN4-13A	BOLT

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WITHOUT NOTICE

WORK ORDER

NO. 34230

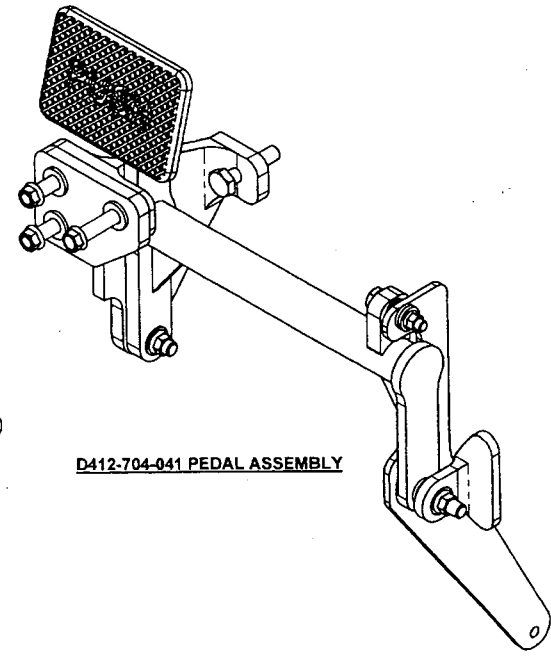
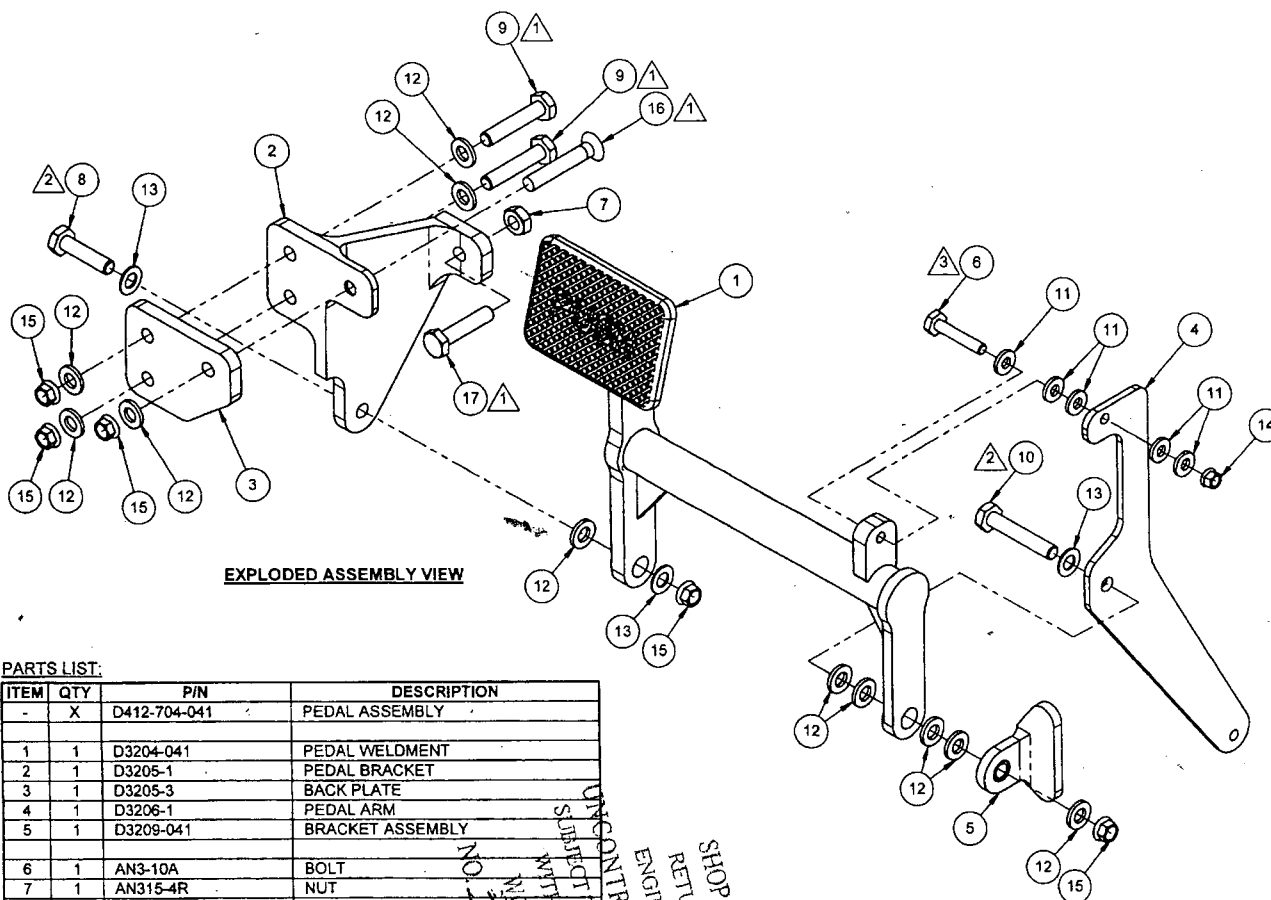
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Revision: A

Date: 04.02.03

W/O 34230



D412-704-041 PEDAL ASSEMBLY

PARTS LIST:

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

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 WITHOUT NOTICE
 WORK ORDER
 NO. 100

- NOTES:**
- 1 INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
 - 2 TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
 - 3 TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).

RELEASED
07.01.30

A	07.01.23	NEW ISSUE	DESCRIPTION
REV	DATE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DESIGN	DRAWN BY	DRAWING NO.	REV. A
C.B.	C.B.	D412-704-041	SHEET 1 OF 1
CHECKED	APPROVED	TITLE	SCALE
CE	[Signature]	PEDAL ASSEMBLY	1:2
DATE	07.01.23	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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